

734-011

Dart Aerospace Ltd.

Date: Wednesday, 22/04/2009 11:40:09 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GHW ASSEMBLY R22
Job Number	: 47366A		
Estimate Number	: 10789		
P.O. Number	:	Part Number	: D022734041
This Issue	: 22/04/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3380 REV B
First Issue	: //	Project Number	: N/A
Previous Run	: 30765A	Drawing Revision	: B
Written By	:	Material	:
Checked & Approved By	: <u>JUL 09.04.22</u>	Due Date	: 15/06/2009
Comment	: Est Rev:B 05.08.19 Revised per CHG002 KJ/RF		

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Note: If D022-734-041 is a W/O on it's own,

Copy bluefiles and create labels per PPP D022-734-041

CHG002

N/A

2.0

D33571

Wheel Shaft

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3357-1

Wheel Shaft

325167

Pc 09.04.29

3.0

D33573

Lock Shaft

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3357-3

Lock Shaft

325168

Pc 09.04.29

4.0

D33591

Spacer

**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3359-1

Washer

822552

Pc 09.04.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: GHW ASSEMBLY R22

Job Number: 47366A

Part Number: D022734041

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 5.0

D3379041

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3379-041

Arm Weldment

~~B22353~~

B23506

plc 09.04.29

✓ 6.0

D33801

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3380-1

Handle

~~B23506~~

B22353

plc 09.04.29

✓ 7.0

D33811

Handle Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3381-1

Label

B29494

plc 09.04.29

✓ 8.0

D3399041

Wheel Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3399-041

Wheel Assembly

B29916

plc 09.04.29

✓ 9.0

GP1R

Black Vinyl Grip



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 GP-1R

Black Vinyl Grip

M16871

plc 09.04.29

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Job Number: 47366A

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Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 10.0

VA1140

Snap Button



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 VA-1140

Snap Button

m16372

Ppl09.04.29

✓ 11.0

159016

3/4"-16 UNF Thick Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 159-016

3/4"-16 UNF Thick Nut, Span

m16905

Ppl09.04.29

✓ 12.0

178039

1/2"-20UNF Nylon Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 178-039

1/2"-20 UNF Thin Nylon Lock Nut, Span

m16905

Ppl09.04.29

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per Dwg D3380

A/R

262 Locktite

m1110005

Ppl09.04.29

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S0264/29 (H)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

47366

26/5

(K)

SL

Dart Aerospace Ltd

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Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/07 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

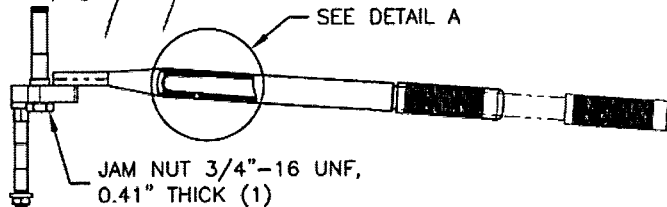
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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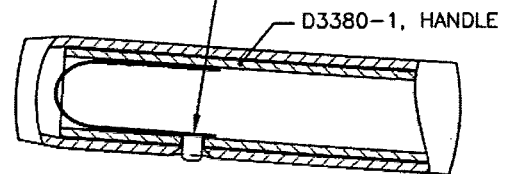
DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3380	REV. B SHEET 1 OF 2
DATE 05.07.21		TITLE GROUND HANDLING ASS'Y	SCALE 1:8
A	04.12.13	NEW ISSUE	
B	05.07.21	ADD LOCKTITE	

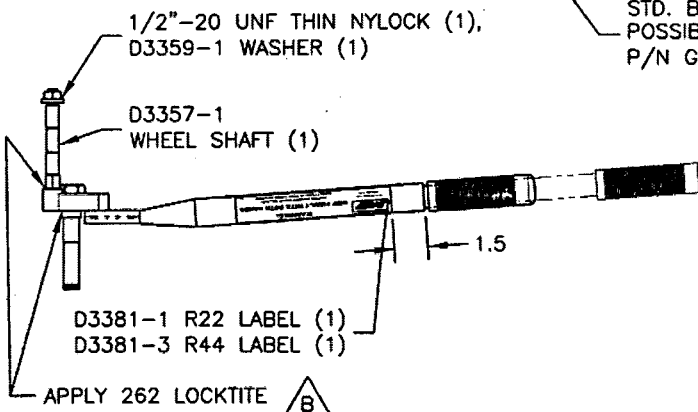
RELEASED
[Signature]
05/08/15



0.300 SNAP BUTTON,
POSSIBLE SUPPLIER:
REID TOOLS SUPPLY CO.,
P/N VA-1140.
INSTALL BUTTON TO
HANDLE D3380-1.

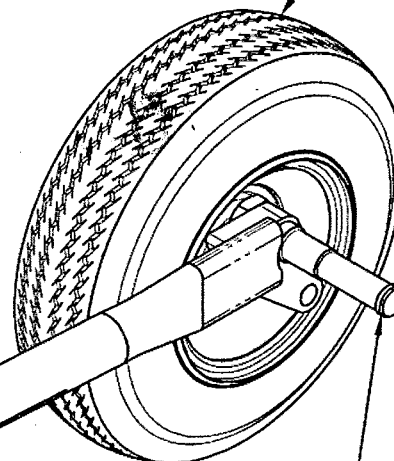


DETAIL A
SCALE 1:2



STD. BLACK VINYL GRIP, 1.000 I.D. x 4.75 LONG
POSSIBLE SUPPLIER, REID TOOLS SUPPLY CO.
P/N GP-1R (1)

D3399-041
WHEEL ASS'Y (1)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *[Handwritten: 1513204]*

ISOMETRIC VIEW
SCALE 1:4

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Dart Aerospace Ltd

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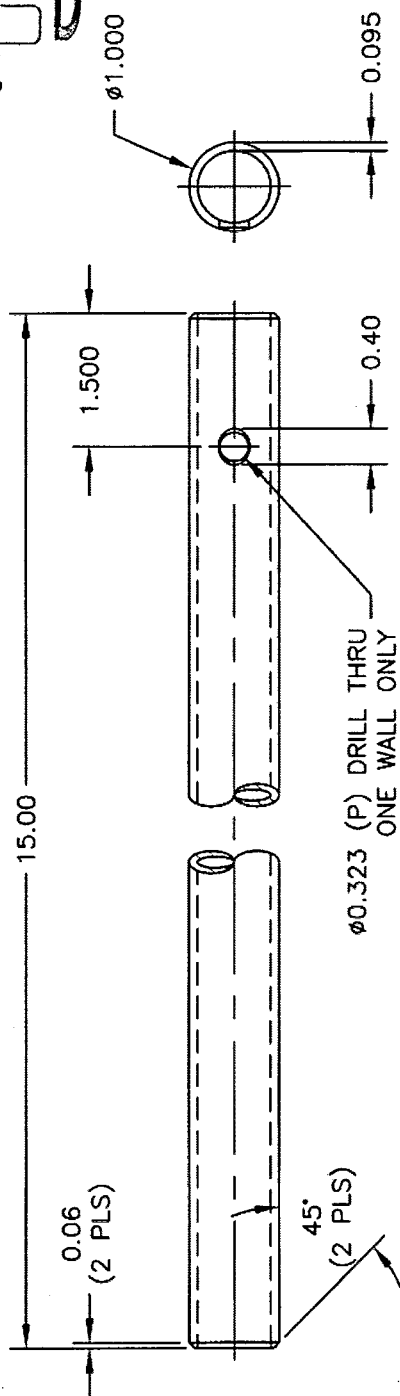
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 3	DRAWN BY 74	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 6	APPROVED <i>[Signature]</i>	DRAWING NO. D3380	REV. B SHEET 2 OF 2
DATE 05.07.21		TITLE GROUND HANDLING ASS'Y	SCALE 1:2

RELEASED
[Signature]
05/08/15



D3380-1 HANDLE

NOTES:

- 1) MATERIAL: 1018-1025 ROUND TUBING MILD STEEL SEAMLESS (REF. DART SPEC. M1018TR1.000)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 0005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47366A

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